

Date: Thursday, 23/10/2008 7:20:36 AM  
 User: Linda Lacelle

## Process Sheet

|   |   |
|---|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services   | <b>Drawing Name</b> : TUBE                                  |
| <b>Job Number</b> : 42879   |   |
| <b>Estimate Number</b> : 13490  |   |
| <b>P.O. Number</b> :  | <b>Part Number</b> : D37701                                 |
| <b>This Issue</b> : 23/10/2008 <b>S.O. No.</b> :  | <b>Drawing Number</b> : D3770 REV B                         |
| <b>Prsht Rev.</b> : NC  | <b>Project Number</b> : N/A                                 |
| <b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB   | <b>Drawing Revision</b> : B                                 |
| <b>Previous Run</b> : 40978   | <b>Material</b> :   |
| <b>Written By</b> :   | <b>Due Date</b> : 30/10/2008 <b>Qty:</b> 16 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> :  |   |
| <b>Comment</b> : Est Rev:A 08-07-21 revB as per dwg DD verified by:EC<br>Est Rev:B Added Drilling Tooling 08-08-26 JLM Verified By:EC |   |

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T1000W065

6061T6 RD TUBE 1.00 x .065w



Comment: Qty.: 1.1926 f(s)/Unit Total : 23.8518 f(s)

6061T6 TUBE (1.00" x 0.65" wall)

batch: M 108077

FF 08/10/23

(16)

2.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-cut tube to lenght as per dwg D3770

2-drill holes thru to finish size as per dwg D3770 Using DT9410, Locate tube on stop labelled #1 and then drill holes labelled #1

3- deburr

FF 08/10/23

(16)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/23

(16)

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1

08/10/27

(16X)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 42879

Part Number: D37701

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



SD



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION ,

08-10-27

✓16

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 251

8/10/27

16x

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/31

Job Completion



MF 08-10-30

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

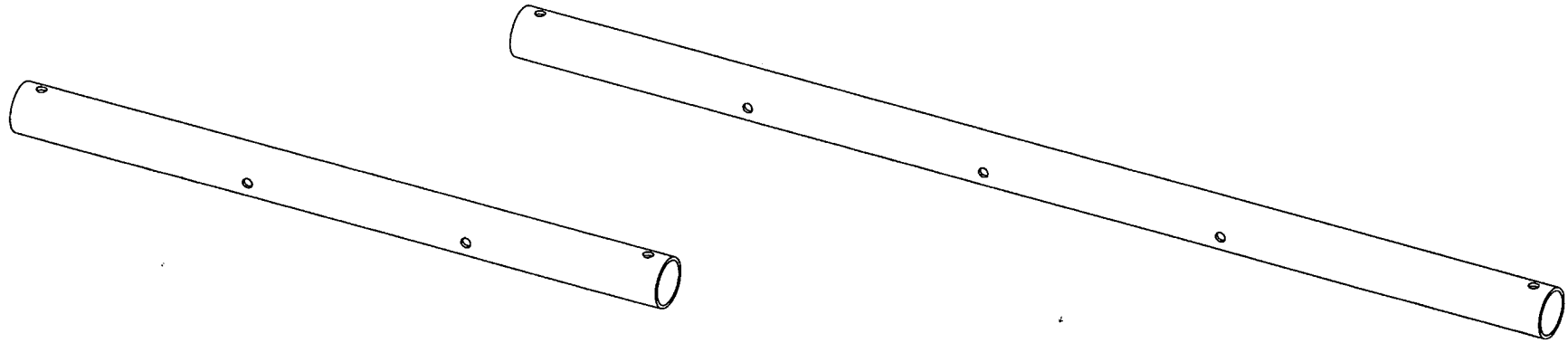
C

B

B

A

A



**D3770-1 TUBE**

**D3770-3 TUBE**

*W/0 428 701*

*REL 08-07-10 701*

**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3770-1, 0.25 lbs  
D3770-3, 0.40 lbs

|            |                            |  |              |
|------------|----------------------------|--|--------------|
| B          | CHANGE HOLES SIZE TO 0.201 | HS   | 08.06.23     |
| A          | NEW ISSUE                  | HS   | 08.06.04     |
| REV.       | DESCRIPTION                | BY   | DATE         |
| DESIGN     | HS                         | DART AEROSPACE LTD   |              |
| DRAWN      | HS                         | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | <i>[Signature]</i>         | DRAWING NO.  | REV. B       |
| MFG. APPR. | <i>[Signature]</i>         | D3770  | SHEET 1 OF 3 |
| APPROVED   | <i>[Signature]</i>         | TITLE  | SCALE        |
| DE APPR.   | <i>[Signature]</i>         | TUBE   | NTS          |
| DATE       | 08.06.23                   | COPYRIGHT © 2008 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

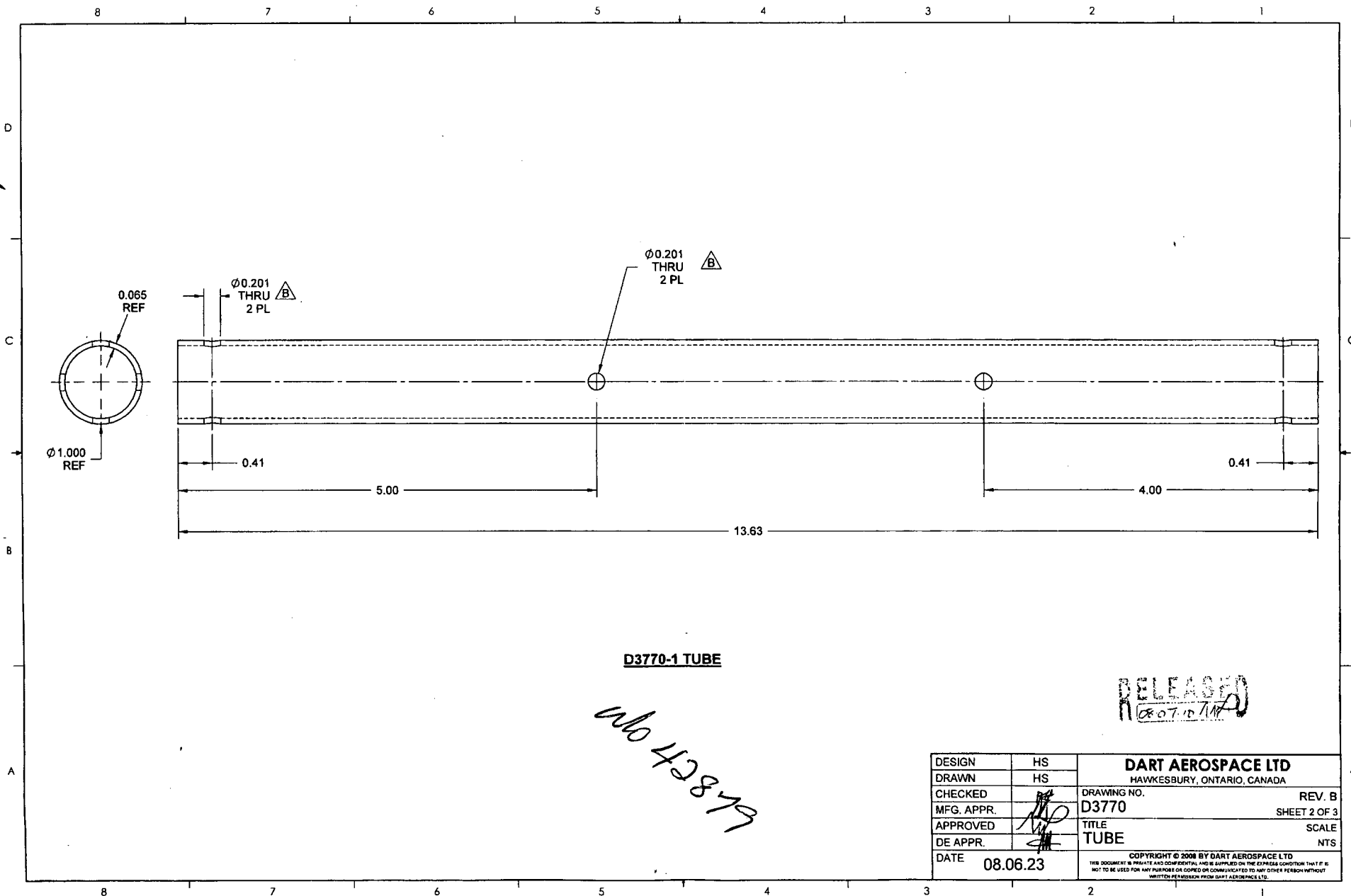
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

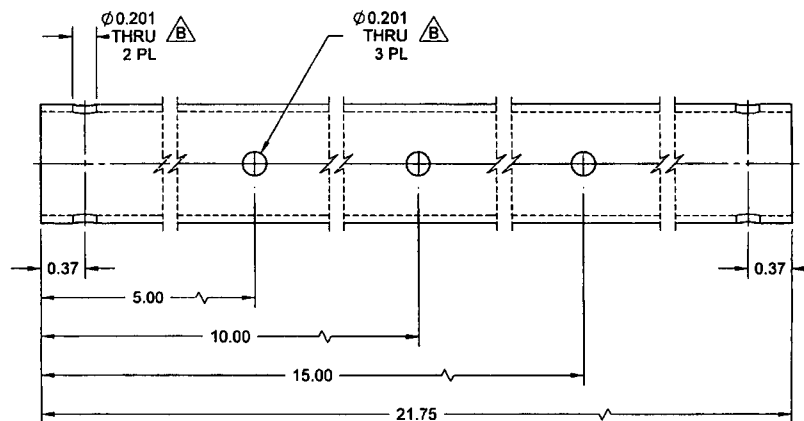
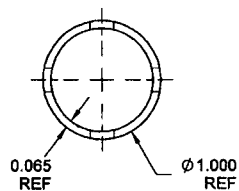
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | HS       | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      | HS       | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    |          | DRAWING NO.   | REV. B       |
| MFG. APPR. |          | <b>D3770</b>  | SHEET 2 OF 3 |
| APPROVED   |          | TITLE   | SCALE        |
| DE APPR.   |          | <b>TUBE</b>   | NTS          |
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**D3770-3 TUBE**

RELEASED  
08-07-10

Mo 42879

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | HS       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | HS       |  |              |
| CHECKED    | PA       | DRAWING NO.  | REV. B       |
| MFG. APPR. | MA       | D3770  | SHEET 3 OF 3 |
| APPROVED   | MA       | TITLE  | SCALE        |
| DE APPR.   | MA       | TUBE   | NTS          |
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